

Claims:

We claim:

1. A shell for a header for a water treatment module, comprising:
 - a) a shell having an outer surface and at least one recess for receiving ends of filtration membranes;
 - b) at least one protruding member extending from the shell to an interior of the recess
 - c) at least one injection duct extending through the protruding member for injecting resin from outside the shell into the interior of the recess,
- 10 the injection duct having an inlet open to the outer surface of the shell and a discharge outlet open to the interior to the recess.
2. The header according to claim 1 wherein the at least one protruding member comprises a needle, the needle having a lower end fixed to the shell and an upper end extending into the recess.
- 15 3. The header according to claim 2, wherein the injection duct extends from the lower end of the needle to the upper end of the needle.
4. The header according to claim 3 wherein the injection duct has an axial passage that extends from the lower end of needle to a point near the upper end, and a radial passage that extends from the upper end of the axial
- 20 passage to the sidewall of the needle.
5. The header according to claim 4 wherein the radial passage extends through the width of the needle, providing two discharge outlets.
6. The header of claim 1 wherein the protruding member passes through an area of the shell adapted to contain a permeate cavity.
- 25 7. The header of claim 1 wherein the discharge outlet is located within an area of the shell adapted to contain a block of potting material holding membranes in the shell.

8. A method of potting membranes in a container comprising the steps of inserting ends of the membranes into the container and injecting resin directly into a space between ends of adjacent membranes.
9. The method of claim 8 further comprising placing a fugitive material in the container before inserting ends of the membranes into the container, the ends of the membranes being inserted into the fugitive material.
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10. The method of claim 9 wherein the resin is injected through the fugitive material.
11. The method of claim 9 wherein the fugitive material is provided in at least two layers.
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12. The method of claim 11 wherein one of the layers of fugitive material comprises a base layer that is resistant to the insertion of the ends of the membranes.
13. A method of potting membranes comprising the steps of (a) providing a first layer of a fugitive potting material into a potting container, (b) providing a second layer of a fugitive potting material in the potting container, (c) inserting the membranes at least partially into the second layer but not completely through the first layer, (d) providing and solidifying a potting material around the membranes outside of either the first or second layer and (e) removing the fugitive potting materials from the potting container.
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14. The method of claim 13 wherein the second layer is less resistant to penetration on the membranes than the first layer.
15. The method of claim 14 wherein the potting container is a header shell and, in step (d) the potting material adheres to the header shell.
- 25 16. The method of claim 14 further comprising inserting the membranes completely through the second layer, sensing the increased resistance to fiber

penetration as or after the membranes contact the first layer, and stopping insertion of the membranes as or after the increased resistance is sensed.